Work Order ID 54338

1



Page 1

December 8, 2009 8:47:49 AM Item ID: D3768-3 Accept Setup Start **Revision ID:** Stop Item Name: Front Outboard Leg, LH Start Qty: 20.00 **Start Date:** 08/12/2009 **Cust Item ID:** Required Date: 16/12/2009 Req'd Qty: 20.00 **Customer:** Reference: Run Start Date: //// **Process Plan:** Approvals: Tooling: Date: Stop Date: QC: Date: Sequence ID/ Operation Set Up/ Plan Reject Draw Reject Draw Accept Insp. Work Center ID Description Stamp **Run Hours** Number Rev. Qty Qty Number Code **Draw Nbr Revision Nbr** D3768 Rev A 100 0.00 Small Fab 20 Small Fab 0.00 Memo Small Fab 1-CUT TUBE TO LENGH AS PER DWG D3768 - 2-DRILL TUBEUSING DT9044 AND AS PER DWG D3768 3-DEBURR SAD 10-01-08 110 QC5- Inspect part completeness to step on W/O OC Memo Quality Control

120

HandFinish

Chemical Conversion Coat per QSI005 4.1

10-00-11

Hand Finishing

Memo

Dart Aerospace L	.td
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W/O:			W	ORK ORDER CHANG	iES	···			-	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	_ Date: _		
	R	esolution:	Disposition	on:	_ QA: N/C C	QA: N/C Closed: Date:				
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NCF	₹)				
DATE	STEP	Description of NC			Section B Verific			Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector	
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Work Order ID 54338



Page 2

December 8, 2009 8:47:49 AM

Item ID:

D3768-3

Accept



Setup Start

Stop

101



Revision ID:

Item Name:

Front Outboard Leg, LH

Start Date: Required Date: 15/12/2009

08/12/2009

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

0.00

Date:

Stop



Sequence ID/ **Work Center ID**

130

Powdercoat

Powder Coating

Operation Description

Fire Red(Ref:4.3.5,10) per QSI005 4.3

Memo

Set Up/ **Run Hours**

Number

Draw Rev.

Plan Code

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

10/01/11

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

BX 10-01-12



Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

10-1-12

Dart Aerospace Ltd

W/O:	Орио		WO	DI ODDED OLIANO	<u> </u>					
W/O:	<u> </u>		WO	RK ORDER CHANG	IES					
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Part No	:	PAR #:	Fault Categ	ory:	_ NCF	R: Yes	No DQ	A :	_ Date: _	
Resolution:			Disposition	:	_ QA:	N/C CI	Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	()			
		Description of NC		Corrective Action Section			Vorifi	oation	A	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		Verification Section C	Approval Chief Eng	QC Inspector
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Work Order ID 54338



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December 8, 2009 8:47:49 AM

Required Date: 16/12/2009

Item ID:

D3768-3

Accept



Setup Start

Stop



Revision ID: Item Name:

Front Outboard Leg, LH

Start Date:

08/12/2009

Start Qty: 20.00

Reg'd Qty: 20.00

Operation

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:_____

Tooling:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/

Work Center ID

160

QC:

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Draw Number Draw Rev.

Date:

Plan Code Accept Qty

Reject Reject Qty

Insp. Stamp Number

Memo

0.00

0.00

Quality Control

Dart Aerospace Ltd

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W/O:			W	ORK ORDER	CHANGES			· · · · · · · · · · · · · · · · · · ·		
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Part No	:	PAR #:	Fault Cat	tegory:	NC	R: Yes	A :	Date:		
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NCR:		-	WORK ORI	DER NON-COI	NFORMANC	E (NCF	?)			
DATE	STEP	Description of NC	Corrective Action Sec			10:	Verific	cation	Approval	Approval
- DAIL	JILI	Section A	Initial Chief Eng	Action De Chief		Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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Picklist Print

December 8, 2009 8:47:53 AM

Work Order ID: 54338

Parent Item:

D3768-3

Parent Item Name: Front Outboard Leg, LH

Comments:



Start Date: 08/12/2009

Required Date: 16/12/2009

Start Oty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6T1.000W065		Purchased	No			100	f	58 3994	17.9832	-		

6061T6 RD TUBE 1.00 x .065w

Warehouse Loc Qty Loc Code Location Main Warehouse MAT 58.3994082 110778 2.18 111029 56.2194082

M113511

SAD 10-01-08

17.9832

Dart Aerospace Ltd

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W/O:		***************************************	WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	Ву	' [Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Y	es No	DQA	4:	_ Date: _	<u> </u>
		olution:								
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial	ion B	Verification			Approval	Approval	
DAIL	JILF	Section A		Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector
										<u> </u> -

RETULE: ENGINEER: : UNCONTROL SUBJECT TO AND AND AND A WITHOU: 1 С D3768-4 FRONT OUTBOARD LEG. RH DELEA D3768-3 FRONT OUTBOARD LEG, LH **D3768-1 FRONT INBOARD LEG** 08.06.04 A NEW ISSUE REV. DESCRIPTION BY DATE DESIGN HS DART AEROSPACE LTD NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR
AMS 4082 OR QQ-A-220/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: INA DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3768 SHEET 1 OF 4 MFG. APPR. APPROVED TITLE SCALE FRONT LEG NTS DE APPR COPYRIGHT © 2008 BY DART AEROSPACE LTD DATE 6) IDENTIFICATION: N/A 08.06.04 THIS DOCUMENT IS PRIMATE AND CONTRIBUTE. AND IS SUPPLIED OF THE EXPRESS CONGITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OF COMMUNICATED TO ANY OTHER PERSON WITHOUT WHITTEN PERSONS OF FROM DATA TARGERACE, IT.D. 7) WEIGHT: 0.19 lbs

7

8 Ø0.323 THRU 2 PL Ø1.000 REF 0.065 REF 0.38 -0.38 - 10.25 **D3768-1 FRONT INBOARD LEG** DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN HS DRAWN HS DRAWING NO. CHECKED REV. A MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE

7

DATE

DE APPR.

08.06.04

FRONT LEG

COPPRESENT 6 2008 BY DART AEROSPACE LTD

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Ø0.323 THRU (2PL) 0.065 REF - Ę Ø1.000 REF SECTION E-E 3/6 - 0.38 10.25

D3768-3 FRONT OUTBOARD LEG, LH

WO 54338

DESIGN	HS	DART AEROS	PACE LTD					
DRAWN.	HS	HAWKESBURY, ONTARIO, CANADA						
CHECKED	PH-	DRAWING NO.	REV. A					
MFG. APPR.	Mr.	D3768	SHEET 3 OF 4					
APPROVED	111	TITLE	SCALE					
DE APPR.		FRONT LEG	NT\$					
DATE 08.0	06.04	THE DECLARATE AND						

3

Ø0.323 THRU 2 PL 0.065 REF - 0.38 SECTION F-F **—** 0.38 Ø1.000 REF 10.25

D3768-4 FRONT OUTBOARD LEG, RH

WIO5433F

DESIGN	HS	DART AEROSPACE LTD						
DRAWN.	HS	HAWKESBURY, ONTARIO, CANADA						
CHECKED	RH	DRAWING NO.	REV. A					
MFG. APPR.	M	D3768	SHEET 4 OF 4					
APPROVED 19		TITLE	SCALE					
DE APPR.	#	FRONT LEG	NTS					
DATE 08.0	06.04	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IN PRIMATE AND COMPIDENTIAL AND IS SUPPLIED THE EXPRESS CONTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT						

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